Each

Wednesday, 10/11/2006 11:11:22 AM Date: Kim Johnston User: **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : STRAP Job Number : 28914B : 10729 **Estimate Number** : NIA : D23245 Part Number P.O. Number S.O. No. : NIA : 10/11/2006 : D2324 REV C This Issue **Drawing Number** : N/A Prsht Rev. Project Number : N/M-Type : SMALL /MED FAB First Issue **Drawing Revision** : 28062B Material **Previous Run** : 10/30/2006 **Due Date** Written By Checked & Approved By Reformat; Incorporated D2324-3 & D2324-5 Comment : Est. E 03.02.28 J/RF **Additional Product** Job Number: Description: Sea. #: Machine Or Operation: M304S16GA 1.0 304/316 .063 Sheet Comment: Qty.: 0.0184 sf(s)/Unit Total: 0.0368 sf(s)304/316 .063 Sheet M 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D2324 06 10 12 Dwg Rev: C Prog Rev: C 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: DIMENSIONAL CHECK





Inspect dimensions per template D2324-5T1

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary



Dart Ae	rospace Li	td		·					
W/O:			W	ORK ORDER CHANGES				· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Dorf No	_	DAD #-	Fault Cata	NO.	D. V.	(C) po		D	<u> </u>
Part No	•	PAR #:	Fault Cate	gory: NC	QA: N	I/C Close	d:	Date: <u>_</u> Date:	<u> </u>
NCR:			WORK ORD	ER NON-CONFORMANC	E (NCF	R)			
		Description of NC		Corrective Action Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
							:		
								1	

NOTE: Date & initial all entries

Wednesday, 10/11/2006 11:11:22 AM Date: Uşer: Kim Johnston **Process Sheet** Drawing Name: STRAP Customer: CU-DAR001 Dart Helicopters Services Job Number: 28914B Part Number: D23245 Job Number: Seq. #: Description: **Machine Or Operation:** PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_ QC21 7.0 Comment: FINAL INSPECTION/W/O RELEASE C Local volte Job Completion

Dart Ae	rospace	Ltd								
W/O:			WC	RK ORDER CHAI	NGES				4	
DATE STEP		PROCEDURE CHANGE			1	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:					_ Date: _ _ Date: _	
NCR:			WORK ORDI	ER NON-CONFOR						
		Description of NC	Description of NC Correcti		Action Section B		Verification		AI	A
DATE	STEP	Section A	Initial Chief Eng	Action Description	on s	Sign & Date	Secti		Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	289148
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST							
	X	First Artic	:le	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	-Co	omments
R0.38	+/-0.030	R 0.38			vern		
Ø0.257	+0.006/-0.001	0.258	1		vern		
Ø0.191	+0.005/-0.001	0.197	1		VerN		
0.750	+/-0.010	0.755	1		Vern		
0.375	+/-0.010	0.375	1		VerN		
1.875	+/-0.010	1.883	1		verN		
3.000	+/-0.010	3.000	V		vern		
3.375	+/-0.010	3.380	J		vern		
	net soll	Andiand burn		,	Dantatura A.		NI/A
Measured by:		Audited by: Date:			Prototype Appr	oval: Date:	N/A N/A
Date: C	× 10 12	Date.	No-10.	/3		Jaie.	IN/A

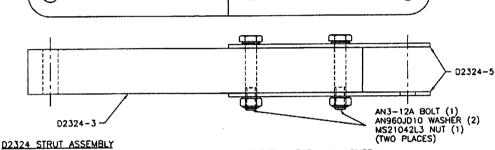
Rev	Date	Change	Revised by	Approved	d
Α	06.06.05	New Issue	KJ/JLM	\(\(\lambda \) \(\lambda \) \(\lambda \)	
				$\overline{}$	



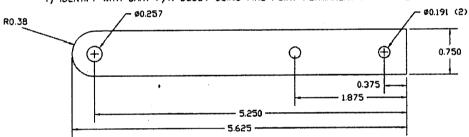
	•		
DESIGN B WILLIAMS	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED ;	APPROVED_A	DRAWING NO.	REV. C
#	#	D2-324 SHEET	1 OF 1
DATE		TITLE	SCALE
04.12.14		STRUT	
Α	94.11.08	NEW ISSUE	
В	96.05.07	UPDATE MATERIALS	
	04.12.14	UPDATE NOTES	

04.12.16

6.000(REF) O 0



1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

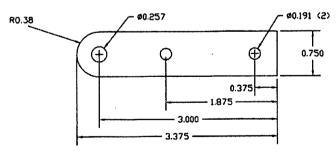
6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL: (REF DART SPEC. M6061T680.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



D2324-5

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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